

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011371**Date Inspected:** 22-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Zong Chong biao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**Bay-5**

This QA Inspector observed the following work in progress:

FCAW (Flux Cored Arc Welding) welding of weld joint 11 located on 11TR3-007. Welder is identified as 066912. ZPMC Quality Control (QC) is identified as Zong Chong biao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-BT-2132.

This QA Inspector observed the following work in progress:

FCAW (Flux Cored Arc Welding) welding of weld joint 014 located on 11TR3-009. Welder is identified as 066734. ZPMC Quality Control (QC) is identified as Zong Chong biao. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U5-7.

**Magnetic Particle Testing (MT)**

This Quality Insurance Inspector (QA) performed 15% verification Magnetic Particle Testing (MT) for OBG segment 8CW, Deck Panel Diaphragm to U-rib welds area. This weld was previously tested and accepted by ZPMC QC MT technicians.

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## WELDING INSPECTION REPORT

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The weld designations reviewed are as follows:

DP-094-001-PP68-036,038,040,041,043,045,046,,048,049,051,053,056,054,057,059,061

DP-094-001-PP69-062,064,066,067,069,071,074,072,075,077,079,082,80,83,085,087

DP-121-001-PP68-051,049,047,054,056,059,057,060,064,067,065,068,070,072,075,073,076,078,080

DP-121-001-PP69-085,083,081,086,088,090,093,091,094,096,098,101,099,102,104,106,109,107,110,112

DP-148-001-PP68-020,018,016,021,023,025,028,026,029,031,036,034,037,039,044,042,045,049,052,050,053

DP-148-001-PP69-062,060,058,063,065,067,070,068,071,073,075,078,076,079,081,084,085,083,087,089,091.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhu,Surendra	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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